

Date: Tuesday, 03/10/2006 8:21:11 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET (6061)
Job Number	: 28811		
Estimate Number	: 12482		
P.O. Number	: <i>N/A</i>	Part Number	: D6102013
This Issue	: 03/10/2006	Drawing Number	: D6102 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: D
Previous Run	: 28289	Material	: <i>N/A</i>
	Type : PURCHASED PARTS	Due Date	: 10/10/2006
Written By	: _____	Qty:	80
Checked & Approved By	: _____	Um:	Each
Comment	: Est Rev:A New Issue 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

Comment: Issue P/O: *2165**C20610/03*

- a) Description: Aluminum Billet
 - b) 7.000" x 6.500" x 2.000" thick
 - c) Tolerance on all dimensions is +0.06/0.00
 - d) Grain direction along 6.500" length
 - e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
- Material release certificate is required

2.0

D6102013P

6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)

6061-T6 6.0x11.0x5.0

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

*PV 06/10/17**80*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check certification to Dwg D6102 for compliance

*T36 06.10.17**80*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/10/2006 8:21:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 28811

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PV 4/19/17

80

6.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

80
OP 06/10/17

Job Completion



U 06.10.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

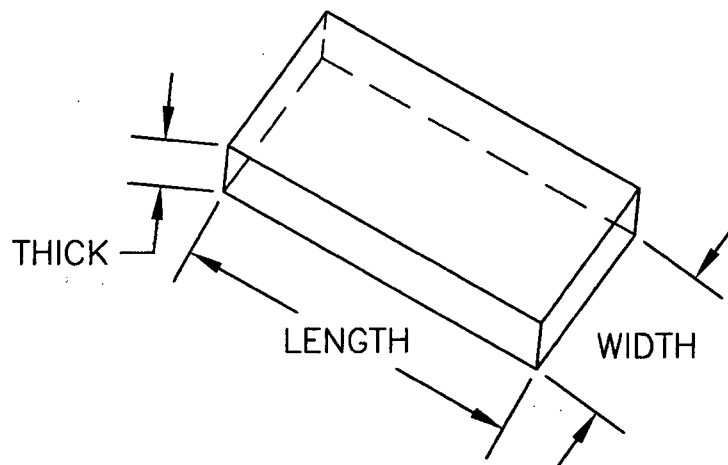
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

VPK METAL DART AEROSPACE

ALUMINUM 6061-T6
2ND THICKEN 6500" X 1000"
PART NO.

09/20/2006 16:24 FAX

09/20/2006 17:16

9053379559

09/20/2004 11:16 FAX 410 162 8262

RAPIDEX

C STEINER

Certificate of Mill Test Results

EL REC 020205-001 50106

Pg 1/1

FORM 0000245

Warning: This data is only valid if the test
specimen is the product of the factory in this
condition from time made at approved jobs

Signed by

MAN

010/014

PAGE 11

012/014

S.C. ALPROM S.A. SLATINA	CERTIFIED ISO 9001 ISO 9001/2004 No. 2574002	MILL TEST CERTIFICATE	EN 16504 2.1	No. 0010
-----------------------------	-------------------------------------------------	--------------------------	-----------------	-------------

CONTRACT/ORDER : 119 RONLISA 00300
BILL OF DELIVERY : 87214
TRUCK/CONTAINER : CLHU 9425714

MATERIAL : ALUMINUM PLATES

ALLOY : 6061
DIMENSIONS (mm) : 2
- 2
- 1

1277443/1443

57403371443

TEMPER TEST

ACCORDING TO

ASTM B209/A138 QQ-A20041

MECHANICAL PROPERTIES

1 MPa = 1 N/mm² = 0.145 kgf = 0.102 kgf/mm²

LOT / BATCH	CASE	Specified values	UTS kgf	YTS kgf	Elong. % mm	Reduc. area %
UN037 2402	018	2,765.002	44.7	40.8	12	12
UN039 2407	042-044	16,852.716	49.4	38.9	12	12
			46.5	44.9	8	8
			46.1	43.8	10	10

CHEMICAL ANALYSIS

BATCH	Si	Fe	Cr	Mn	Mg	Cu	Zn	Ni	Ti	Al
2402	0.07	0.04	0.18	0.13	0.06	0.002	0.007	0.007	0.019	RESA.
2407	0.05	0.46	0.22	0.74	1.01	0.008	0.028	0.007	0.018	RESA.
Min.	0.4	0.7	0.13	0.19	0.5	0.24				RESA.
Max.	0.8		0.4	0.19	1.2	0.46	0.05	0.05	0.16	
Comp.	Others Each: 0.05									
Others Total: 0.10										

REMARKS: LG 333-01-0182755 X9

We hereby certify that the results reported herein are based on standard and proper procedures in the performance of the
laboratory operations under strict control. It is our policy to conduct all testing under strict control.

DATE: 12/02/2006
QUALITY CONTROL DEPT. - S.C. ALPROM S.A.
C.T.G. Usat

000 F-75-04-023 Rev. 9

REMARKS
C.T.G.
31